101893

Page 1

	May-21-13 12:.	35:22 PM											
- - - 	Item ID: Revision ID:	D3034-3			Accept	*N900	040	100)*	Setup Star	' *N	S1*	
	Item Name:	Bearpaw	7			•				Stop	· *NI	C 2*	
 	Start Date: Required Date: Reference:	5/21/13 : 6/04/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item I Customer:	D:			*.	IŲ	.7/	
	Approvals:	Process Pl	an:	Date: 13-05-21		Da	 ate:			Run Star	^t *N	R1*	
	••						ate:			Stop	, *N	R2*	
	Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
	Draw Nbr	Re	vision Nbr							·			
	D3034	RE	V C										
	*120 *120* Waterjet FLOW CNC Waterje	et	FLOW WATER JET Memo CUT BLAN	K AS PER FILE D3034-3_	0.00 0.00 BLANK				13	E,	13-6	49	
	130 *130* HAAS 1 HAAS CNC vertical	I machine #1	HAAS CNC VERTICAL Memo 1- Mill as per Folio Rev: 4 Dwg D3034	r Folio FB109	0.00 0.00	MH 13	6/07/ 13101/	, 37 9	_12_	<u> </u>	/3	3/07/0	2

2-Deburr per dwg D3034

108 July 37

N	~	D٠	
1.4	U	٦.	

es)	No

WORK ORDER NON-CONFORMANCE / UPDATE

104	· ,•••	١.
DQA: Sul	Date: 3/07/0#	
OAI	10 - 10	
A Closed	Date: 3/7/10	

										QA CIOSCUL	7 The Date.		
Work Order:	10189	3			DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
	D -303				Rework Scrap]		Skid-tube X	Crosstube Small Fab	Water Jet Engineering Prod. Eng. Coor. Quality			
raicivo.	<u> </u>	5-1-5			ì ⊢	{ I.						· · — ·	
NCR No.	13-	986	1		Use-as-is Work Order Update]		noforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other	
Root				Descri	ption of work order update	Init	tial	Act	tion	Sign &			
Cause	Date	Step	Qty	(or Non-conformance	Chie	f Eng	Descr	ription	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material	13/67/08	130	١	Ran w Mit (rrong operation and clamp. See Domosed	0A 16	S S	SCrof +	Destry. 2ty 1 M123296	MH 13/02/08	J. 02 D	0AS 16	
Setup Other					ochin Malfudni	ارده	oir	Batch #	M123296		•	822042	
Process	1			Z= yvi	schin Malfuchi							13/07/08	
Supplier				:				4 000	\bigcirc \			,	
Training								\$ 290	\sim			1	
Unapproved						İ		4 00 1					
					- F	AULT	CATE	GORY					
Landing	Gear				General							_	
	Bending				Bend	∏ _G	irain			Ovalized		Pressure/Forced	
	Centre No	t Concer	ntric to	o/s	BOM/Route	Н	lardwa	re		Over/Under	tolerance	Temperature/Cure	
	Cracks			2	Broken/Damaged	In	nspecti	on Incomplete		Part Incorred	ct	Weld	
	Crushed/0	Crimped			Burrs	In	struct	ions Incomplete/	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled	
	Cuffs				Contamination	\square	/lainte	nance		Part Moved		_	
	Heat Trea	t			Countersink	Пм	/lislabe	led		Positioned V	Vrong		
	Inspection	Strip in	Tube		Cut Too Short	\square	/lisread	1		Power Loss/	Surge	Other	
	Ripples in	Bend			Drill Holes	По	ffset			Dr. Pax	granscoct I	SUM F	
	Torque W	aves in E	xtrusio	n . 🗀	Drawing	По	ot of C	Calibration		Park	in Machi	conty	
	Turning S	equence			Finish	По	ot of S	Sequence		regster		· · · · · · · · · · · · · · · · · · ·	
			Folio	По	Outside Dimensions			0					

May-21-13 12:35:22 PM

Item ID: **Revision ID:** D3034-3

Accept

N900040100

Setup Start

Item Name: **Start Date:**

5/21/13

Bearpaw

Start Qty: 12.00

Cust Item ID:

Required Date: 6/04/13

Req'd Qty: 12.00

12

Customer:

Tool ID

Reference:

Approvals:

Process Plan: Date:

Tooling:

Date:

Tool # Plan

Code

Reject

Date:

SPC (Y/N):

Set Up/

Date:

Stop

Reject

Qty

Number Stamp

Insp.

Sequence ID/ Work Center ID

140

QC

Quality Control

Operation Description

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

Run Hours

13/07/07

150

QC8- Inspect parts - second check

Memo

Memo

0.00

0.00

13/07/11

Accept

Qty

Quality Control

150 QC:

151

151

Packaging Packaging

Identify as per dwg & Stock Location: PPP

0.00

Memo

											DO	QA: _	Date	::	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	/IANCE / UP	DATE					
											QA Clos	ed:	Date	!:	
Work Orde	oř.					DISPOSITION				AGAINST D	PARTME	NT/P	PROCESS		
Work Ord	٠, .					Rework	7		Skid-tube	Crosstube	7		Water Jet	Engi	ineering
Part I	No.					Scrap	1		Machining	Small Fab	-	Prod.	. Eng. Coor.		Quality
					_	Use-as-is			noforming	Finishing	Rec/	Store	/Packaging		Other
NCR I	۷o.	<u>=</u>				Work Order Update	ַ		Large Fab	Composite			Supplier		
Root					Descri	ption of work order update	T	Initial	Ac	tion	Sign 8	k			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription	Date		Verification	Q	C Inspector
Doc/Data															
Equip/Tooling							1								
Operator															
Material															
Setup			}				İ					1			
Other	\Box		}								ĺ				
Process									:						
Supplier	$ldsymbol{ld}}}}}}$			1											
Training															
Unapproved				<u> </u>							<u> </u>				
							AUI	LT CATE	GORY						
Landi	ng (Gear			_	General		,			_			_	
		Bending			<u> </u>	Bend	lacksquare	Grain		<u> </u>	Ovalized		<u> </u>	-	ire/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route	L	Hardwa	re	<u> </u>	Over/Un		 	 '	erature/Cure
	L	Cracks				Broken/Damaged	<u> </u>	4 '	on Incomplete		Part Inco		<u> </u>	Weld	
		Crushed/	'Crimped			Burrs	L	-1	ions Incomplete/	Unclear	Part Lost		sing	Wrong	g Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Mo	ved			
		Heat Tre	at			Countersink		Mislabe	led		Position	ed Wr	rong	_	
		Inspection	n Strip ir	Tube		Cut Too Short	L	Misread	1		Power Lo	oss/Su	urge	Other	
		Ripples ii	n Bend			Drill Holes		Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

May-21-13 12:35:22 PM

Quality Control

Item ID: D3034-3 Accept *N900040100* Setup Start **Revision ID:** Item Name: Bearpaw *12* **Start Date:** 5/21/13 **Start Qty: 12.00 Cust Item ID:** Required Date: 6/04/13 **Req'd Qty:** 12.00 *12* **Customer:** Reference: Run Process Plan: _____ Date: ___ Tooling: -**Approvals:** Date: Stop Date: SPC (Y/N): Date: _____ Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 190 QC21- Final Inspection - Work Order Release 0.00 *190* QC 0.00 Memo

MC 13-07-16

NCR: Y	'es /	No				WORK ORDER NON-C		MFORM	MANCE / UP	DATE			
											QA Closed:	Date	· ·
Work Orde	ŗ.			·		DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
	_					Rework			Skid-tube	Crosstube Small Fab	Dro	Water Jet d. Eng. Coor.	Engineering Quality
Part N						Scrap Use-as-is			Machining noforming	Finishing		re/Packaging	Other
NCR N	lo	<u> </u>				Work Order Update			Large Fab	Composite	Nec/3tol	Supplier	
Root				Į	Descri	ption of work order update	Ī	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material		į											
Setup	_				•								1
Other	_												
Process												·	
Supplier													
Training							1						
Unapproved							Į						
							AUL	T CATE	GORY				
Landir						General		1			1	_	-
		nding			<u> </u>	Bend	L	Grain			Ovalized	_	Pressure/Forced
	_	ntre Not	Concer	ntric to	o/s	BOM/Route	<u> </u>	Hardwa		<u> </u>	Over/Under	 	Temperature/Cure
	—	acks			<u> </u>	Broken/Damaged	<u> </u>	1	ion Incomplete	_	Part Incorred		Weld
	_	ushed/Cr	imped		<u> </u>	Burrs	\vdash	i	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	-	ffs				Contamination	\vdash	Mainte		_	Part Moved		
	$oldsymbol{arphi}$	at Treat			_	Countersink	<u> </u>	Mislabe			Positioned V		- .
	Inspection Strip in Tube			Cut Too Short		Misread	d		Power Loss/	Surge	Other		
	⊢	oples in B				Drill Holes		Offset					.
	To	rque Wa	ves in E	xtrusio	n	Drawing	1	Out of 0	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish Folio Work Order ID: 101893

D3034-3

Parent Item Name: Bearpaw

101893

D3034-3

Start Date: 5/21/13

Required Date: 6/04/13

Start Qty: 12.00

Required Qty: 12.00

Comments:

Parent Item:

IP REV:A NEW ISSUE 12-04-12 JLM VERIFIED BY:DD

REV:B NOW 1.25" MAT 12-10-15 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB1.250		Purchased	No				sf	190.0000		49.92			
*MUHMW	R1 250°	k							**	50.	00	Ae 1	****
UHMWB 1.250 BLACK				Location	l.	Loc (<u>Oty</u>	Loc Code				13.06	0.09

IPP

MAT019 190 123290 190 123290

Page 1

												DQA:	Da	ite:	
NCR: Y	'es	/ No				WORK ORDER NON-C	O	IFOR!	MANCE / UPD	ATE	OA C	Closed:	 Da	ite:	
Work Orde	er:					DISPOSITION				AGAINST DE					
Part N	lo.					Rework Scrap Use-as-is Work Order Update		1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	R		Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Descri	iption of work order update	1	nitial	Acti	on	Sig	gn &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descri	ption	D	ate	Verificatio	n	QC Inspector
Doc/Data				;											
Equip/Tooling							Ì								
Operator							ļ								
Material				ļ											
Setup					ļ									l	
Other			1		İ										
Process														į	
Supplier														j	
Training]			1							1	
Unapproved															
						F	AUL	T CATE	GORY						
Landi	ng (Gear				General					_			_	_
		Bending				Bend		Grain			Ovali	ized		L	Pressure/Forced
		Centre Not Concentric to O/S				BOM/Route		Hardwa	ire		Over	/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part	Incorre	ct		Weld
		Crushed/	Crimped			Burrs		Instruct	tions Incomplete/U	nclear	Part	Lost/Mi	ssing		Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved
Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short Drill Holes

Drawing

Finish

Folio

Turning Sequence
Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

DART AEROSPACE LTD	Work Order:	161893
Description: Bearpaw	Part Number:	D3034-3
Inspection Dwg: D3034 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimensio n	Accept	Reject	Method of Inspection	Comments
2.500	+/-0.010	1-5025	V		MH-04	Caliper
3.31	+/-0.030	3.3125	J		MH-04	ν.
5.87	+/-0.030	5-875	1		Charos	
9.50	+/-0.030	9.5	J		C10-08	
4.750	+/-0.010	4.748	1		MH-04	-
0.38	+/-0.030	.375				
14.500	+/-0.010	14-50	1		tape	MH-07
25.500	+/-0.010	25.5	1		tape	MH-07
28.25	+/-0.030	26,25	J		tape	M4-07
0.63	+/-0.030	.635	√		M-04	Caliper
11.75	+/-0.030	11.757	J.		cuc-or	1
0.95	+/-0.030	£2P.	J		40 HM	
0.25 x 45°	+/-0.030 x -0.05°	-255	5			
0.06 x 45°	+/-0.030 x -0.05°	. 06	J			\ .
0.25	+/-0.030	. 247	J		ÚH-06	Depth micro
0.375	+/-0.010	.378	V		MH-04	Califric
0.73	+/-0.030	.725	V			1
1.01	+/-0.030	1.02	1			
1.44	+/-0.030	1.434	\checkmark			
1.20	+/-0.030	10203	✓			
1.09	+/-0.030	1,099	J			
Ø0.260	+0.006/-0.001	`560	7			
Ø0.930	+/-0.030	.932	J			
0.30	+/-0.030	231	1			

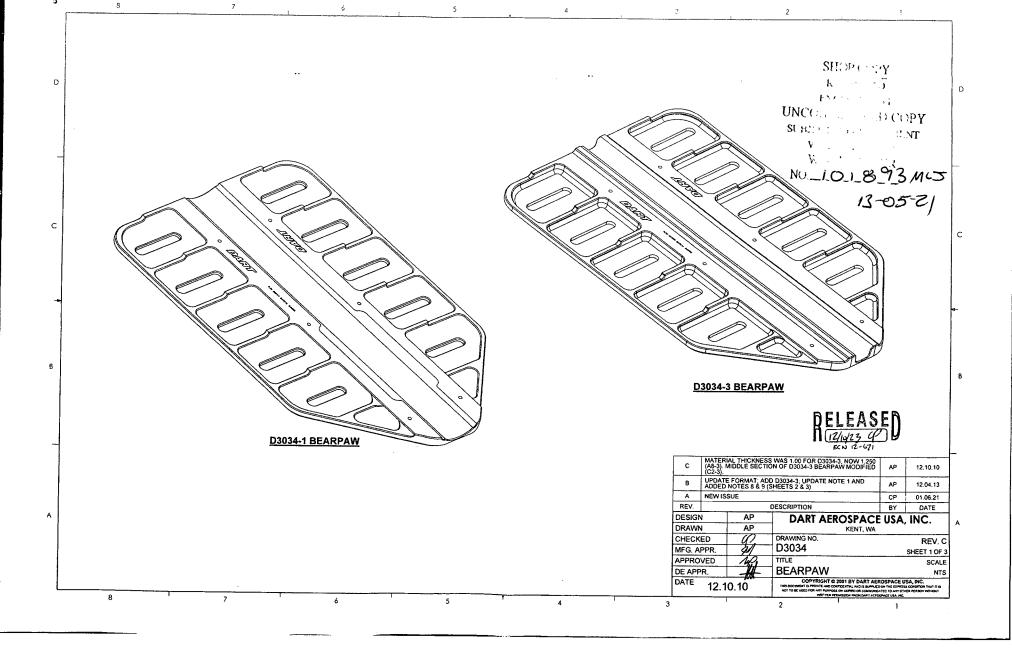
	DPS \	
Measured by: MH /and	Audited by: $\begin{array}{c} 44 \\ 9-89 \end{array}$	Preliminary Approval:
Date: (3/07/6)	Date: 13/07/10	Date:

Rev	Date	Change	Revis	sed by	Approved
Α	13.03.07	New Issue	KJ	AKY.	M.
***************************************				777	

NCR:	Yes	/	No	

										DQA:	Date:		
NCR: Y	es / No				WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:								
			···		DISPOSITION AGAINST DEPAR					-			
Work Orde	r:				_	_		_	_	,,			
Part N	0				Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing				Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other	
NCR N	o				Work Order Update]		Large Fab Composite	: 🗌		Supplier		
Root				Descri	iption of work order update	1 1	nitial	Action		Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chi	ief Eng	Description		Date	Verification	QC Inspector	
Doc/Data													
quip/Tooling			1 1							:	!		
Operator										•			
Material [İ				
Setup									ļ				
Other		1											
rocess						1					•		
Supplier						1					get		
raining [
Jnapproved													
						FAUL	T CATE	GORY					
Landir	ng Gear				General							_	
	Bending				Bend		Grain			Ovalized		Pressure/Forced	
ſ	Centre N	ot Conce	ntric to C	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
	Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorred	ct	Weld	
	Crushed	/Crimped			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs				Contamination		Mainte	enance		Part Moved			
	Heat Tre	at			Countersink		Mislabe	eled		Positioned V	Vrong	 4	
	Inspection	on Strip in	Tube		Cut Too Short		Misread	d		Power Loss/	Surge	Other	
	Ripples i	n Bend			Drill Holes		Offset						
	Torque \	Waves in I	Extrusion	· [Drawing		Out of	Calibration					
	Turning	Sequence	:		Finish		Out of	Sequence					
İ	Wave/Tv	wist in Tu	be	Γ	Folio		Outside	Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



											DQA:	Date	:
NCR:	⁄es	/ No				WORK ORDER NON-C	100	VFORM	MANCE / UPDATE		•		
											QA Closed:	Date	•
Manta Ond						DISPOSITION			AGAI	NST DE	PARTMENT,	PROCESS	
Work Orde	er: –					Rework	1		Skid-tube Crosst	ubo	1	Water Jet	Engineering
Part f	ı.					Scrap			Machining Small		Pro	d. Eng. Coor.	Quality
raiti	\ U					Use-as-is			noforming Finish	_	1	re/Packaging	Other
NCR I	N۸					Work Order Update	1		Large Fab Compo	~ 	1100,0101	Supplier	
110.11	-					Work Order opdate	J		20186 140	J	l		لــا
Root					Descri	ption of work order update		Initial	Action		Sign &		Ī
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data											:		
Equip/Tooling	Ш						1						
Operator	Ш		•										
Material	Ш												
Setup	Ш												
Other	Ш												İ
Process	Ш												
Supplier	Ш												
Training	Ш						İ						
Unapproved			L				<u> </u>						
							AUL	LT CATE	GORY				
Landi					 	General	_	J			ا د د د د	-	7
Bending				Bend	\vdash	Grain		-	Ovalized		Pressure/Forced		
Centre Not Concentric to O/S					^{O/S}	BOM/Route	\vdash	Hardwa			Over/Under	 	Temperature/Cure
		Cracks	. · ·		<u> </u>	Broken/Damaged	-	-	ion Incomplete	\vdash	Part Incorred	⊢	Weld
	-	Crushed/	Crimped		<u> </u>	Burrs	\vdash	-	ions Incomplete/Unclear	<u> </u>	Part Lost/Mi	ssing	Wrong Stock Pulled
	-	Cuffs			<u> </u>	Contamination	\vdash	Mainte		-	Part Moved	.,	
l	Heat Treat				Countersink	Mislabeled				Positioned Wrong			

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

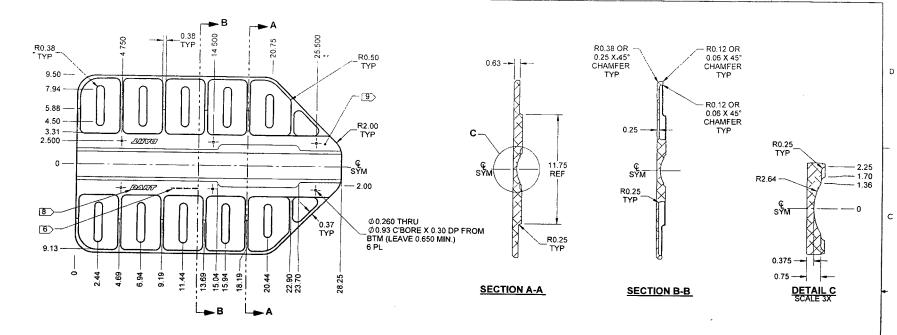
Torque Waves in Extrusion.

Cut Too Short

Drill Holes

Drawing

Finish Folio



0.950

D3034-1 BEARPAW

NOTES:
1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.000 THICK MACHINED TO 0.950 (REF DART SPEC. MUHMWB100)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER "D3034-1" AND BATCH NUMBER "BXXXXXX" IN ACCORDANCE WITH QSI 044 METHOD 6.3

8

С

ACCORDANCE WITH QSI 044 METHOD 6.3

8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.012

9) APPLY R0.12 RADIUS OR 0.06 x 45" CHAMFER TO ALL EDGES ON SIDE SHOWN UNLESS OTHERWISE INDICATED 10) PROFILE PER DRAWING FILE "D3034-1-REVC.STP"

DESIGN	AP	DART AEROSPACE USA, INC.					
DRAWN	AP						
CHECKED	a.	DRAWING NO.	REV. C				
MFG. APPR.	94	D3034	SHEET 2 OF 3				
APPROVED	1480	TITLE	SCALE				
DE APPR.	-	BEARPAW	NTS				
DATE 12.1	0.10	COPYRIGHT © 2001 BY DART AEROSPACE USA, INC. 1/49 DOCUMENT IS PRINATE AND CONTRIBUTIAL AND IS SUPPLIED ON THE EXPRESS CONCRITON THAT IT IS ROT TO BE USED FOR ANY PURPOSE OR COMBUSTACTOR TO WHOSP REPSON WITHOUT WINDERS PRINAESSIN FROM DAYS APPOSED US AS NC.					

2

3

2

										DQ	A :D	ate:	
NCR: Y	es / No				WORK ORDER NON-CONFORMANCE / UPDATE								
										QA Close	d: D	ate:	
Work Orde	ır.				DISPOSITION				AGAINST DE	PARTMEN	IT/PROCESS		
Part No					Rework Scrap Use-as-is Work Order Update	Machining Small Fab Thermoforming Finishing			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other	
Root				Descri	ption of work order update		nitial	Act	ion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verificati	on	QC Inspector
Doc/Data													
Equip/Tooling													•
Operator		,											
Material												٠	
Setup		Ì				İ							
Other			1						•		ļ		
Process													
Supplier													
Training													
Unapproved						1_				<u> </u>			
					<u> </u>	AUI	T CATE	GORY					
Landi	ng Gear			_	General		-		_	7		_	•
	Bendin	g			Bend		Grain		L	Ovalized			Pressure/Forced
	ing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped		o/s	BOM/Route		Hardwa	re		Over/Und	er tolerance		Temperature/Cure	
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incor		_	Weld
	Crushed/Crimped				Burrs	L	Instruct	ions Incomplete/l	Jnclear	Part Lost/	=		Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Move	ed		
	Heat Ti	eat			Countersink		Mislabe	eled		Positione	d Wrong	_	-
	Inspect	ion Strip it	1 Tube		Cut Too Short		Misread	i		Power Lo	ss/Surge		Other
	Ripples	in Bend			Drill Holes		Offset				_		

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

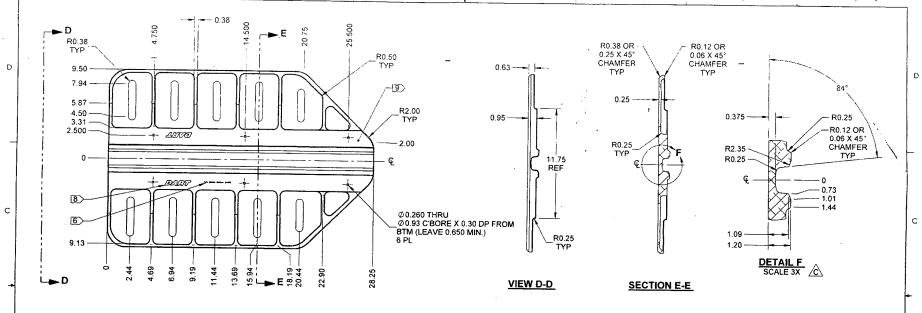
Torque Waves in Extrusion

Drawing

Finish

Folio







D3034-3 BEARPAW

NOTES:
1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.25 THICK MACHINED TO 1.20 (REF DART SPEC. MUHMWB125)

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER "D3034-3" AND BATCH NUMBER "BXXXXXX" IN
ACCORDANCE WITH QSI 044 METHOD 6.3

8

ACCORDANCE WITH QSI 044 METHOU 6.3

7) WEIGHT: 8.59 lbs
8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.012
9) APPLY R0.12 RADIUS OR 0.06 x 45 CHAMFER TO ALL EDGES ON SIDE SHOWN UNLESS OTHERWISE INDICATED
10) PROFILE PER DRAWING FILE "D3034-3-REVC.STP"

DESIGN	ΑP	DART AEROSPACE USA, INC.				
DRAWN	AP					
CHECKED	a.	DRAWING NO.	REV. C			
MFG. APPR.	94	D3034	SHEET 3 OF			
APPROVED	149	TITLE	SCALE NTS			
DE APPR.	-4	BEARPAW				
DATE 12.1	0.10	COPYRIGHT © 2001 BY DART AEROSPACE USA, INC. THE DOCUMENT IS PRIVATE AND COMPORTAL AND IS SUPPLIED OF THE CUPYEDS COMPINED THAT IT IS NOT TO BE VISED AND ANY PURPOSE ON COPIED OR COMMUNICATED TO ANY OTHER PETRON WITHOUT WRITTER PRIVASCOP THOU BOAT A RECOMPLET USA INC.				

2

DQA: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

									QA Closed:	Date:				
Work Orde	Order: DISPOSITION								AINST DEPARTMENT/PROCESS					
,,,,					Rework	Rework Skid-tube Crosstube				Water Jet	Engineering			
Part N	0.				Scrap	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality			
					Use-as-is	The	rmoforming	Finishing	Rec/Sto	e/Packaging	Other			
NCR N	0				Work Order Update]	Large Fab	Composite	:	Supplier				
		_	, ,											
Root					ption of work order update	Initial	i	ction	Sign &					
Cause	Date	Step	Qty		or Non-conformance	Chief En	g Desc	cription	Date	Verification	QC Inspector			
oc/Data	_	1						•						
quip/Tooling														
Operator														
Material						ŀ								
etup]												
Other					·									
rocess														
Supplier		İ				1								
raining					,						•			
Jnapproved														
					F.	AULT CAT	EGORY							
Landin	g Gear				General						_			
	Bending				Bend	Grain	1		Ovalized		Pressure/Forced			
	Centre N	lot Conce	ntric to	o/s	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure			
	Cracks				Broken/Damaged	Inspe	ction Incomplete		Part Incorre	ct	Weld			
	Crushed/Crimped				Burrs	Instru	ctions Incomplete	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled			
Ţ	Cuffs				Contamination	Mair	tenance		Part Moved					
	Heat Treat			Γ	Countersink	Misla	beled		Positioned V	Vrong	: -			
ſ	Inspection	on Strip in	Tube		Cut Too Short	Misre	ad		Power Loss/	Surge	Other			
ĸ.	Ripples i	n Bend			Drill Holes	Offse	t							
*	Torque \	Naves in	Extrusio	n 🗀	Drawing	Out o	f Calibration							
Ţ	Turning	Sequence	!		Finish	Out	of Sequence							
t	Wave/Twist in Tube					Outei	de Dimensions							